

Work Order ID 83871

April-26-12 2:30:19 PM

83871

Page 1

Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg Assembly Hi
 Start Date: 26/04/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M25 Date: 12/04/26 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3065	Rev B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								

40X

12/06/11

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

40

12/06/11

120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

STEP
CELL

40

12.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83871***83871***

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April-26-12 2:30:19 PM

Item ID: D3065-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Leg Assembly Hi

Stop ***NS2***

Start Date: 26/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

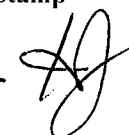
130

QC

Memo

0.00

Quality Control

12/10/12 

R.1206-12

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NOTE: Date & initial all entries

Picklist Print

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Page 1

2

Work Order ID: 83871

83871

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3065-1		Manufactured	No			100	Each	67.0000	1	40			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3065-1

Step Spacer

**

Location

Loc Qty

Loc Code

GA

67

74497

1

81303

14

81304

52

D3065-3		Manufactured	No			100	Each	58.0000	1	40			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3065-3

Step Spacer

**

Location

Loc Qty

Loc Code

GA

51

69827

1

73290

4

75152

14

81306

32

WA

7

81305

7

D3065-5		Manufactured	No			100	Each	78.0000	2	80			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3065-5

Step Leg

**

Location

Loc Qty

Loc Code

GA

78

67222

1

73289

19

79727

14

81308

44

EP 12/06/11
B83872
40x

EP 12/06/11
B83873
32x

EP 12/06/11
B83734
8x

EP 12/06/11
B83874
80x

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 83871

83871

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

D3065-7

Manufactured No

100

Each

63.0000

1

40

D3065-7

Step Spacer

**

Location

Loc Qty

Loc Code

GA

63

73291

7

74499

1

78666

4

81309

7

81310

44

EB 12/06/11
383738
30x
383875 10x

MS20470AD4-4

Purchased

No

100

Each

2,478.000

30

1200

MS20470AD4-4

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

2478

116188

136

116391

66

118614

1087

119109

26

120361

658

121011

505

EB 12/06/11
M121556
1200

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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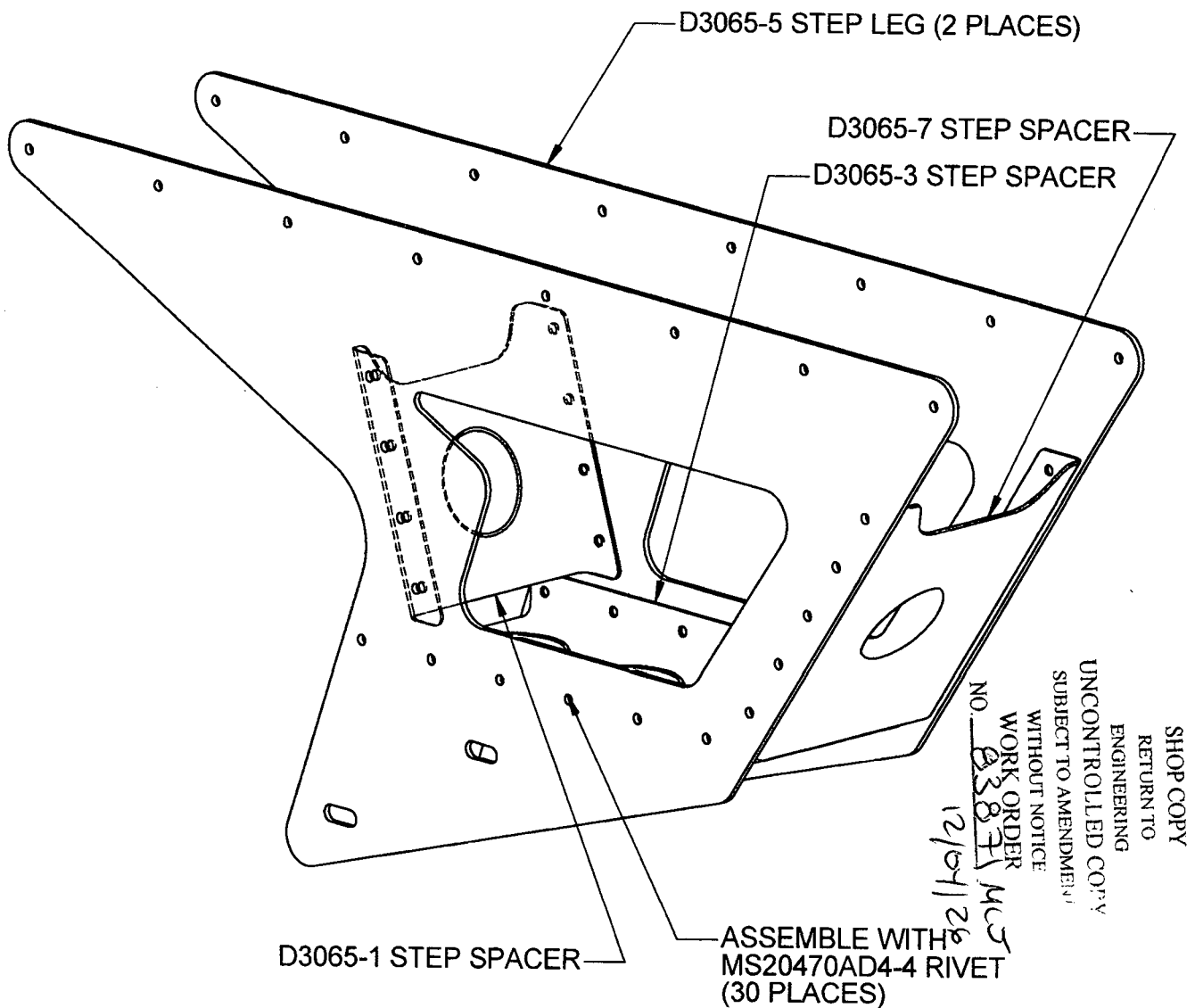
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

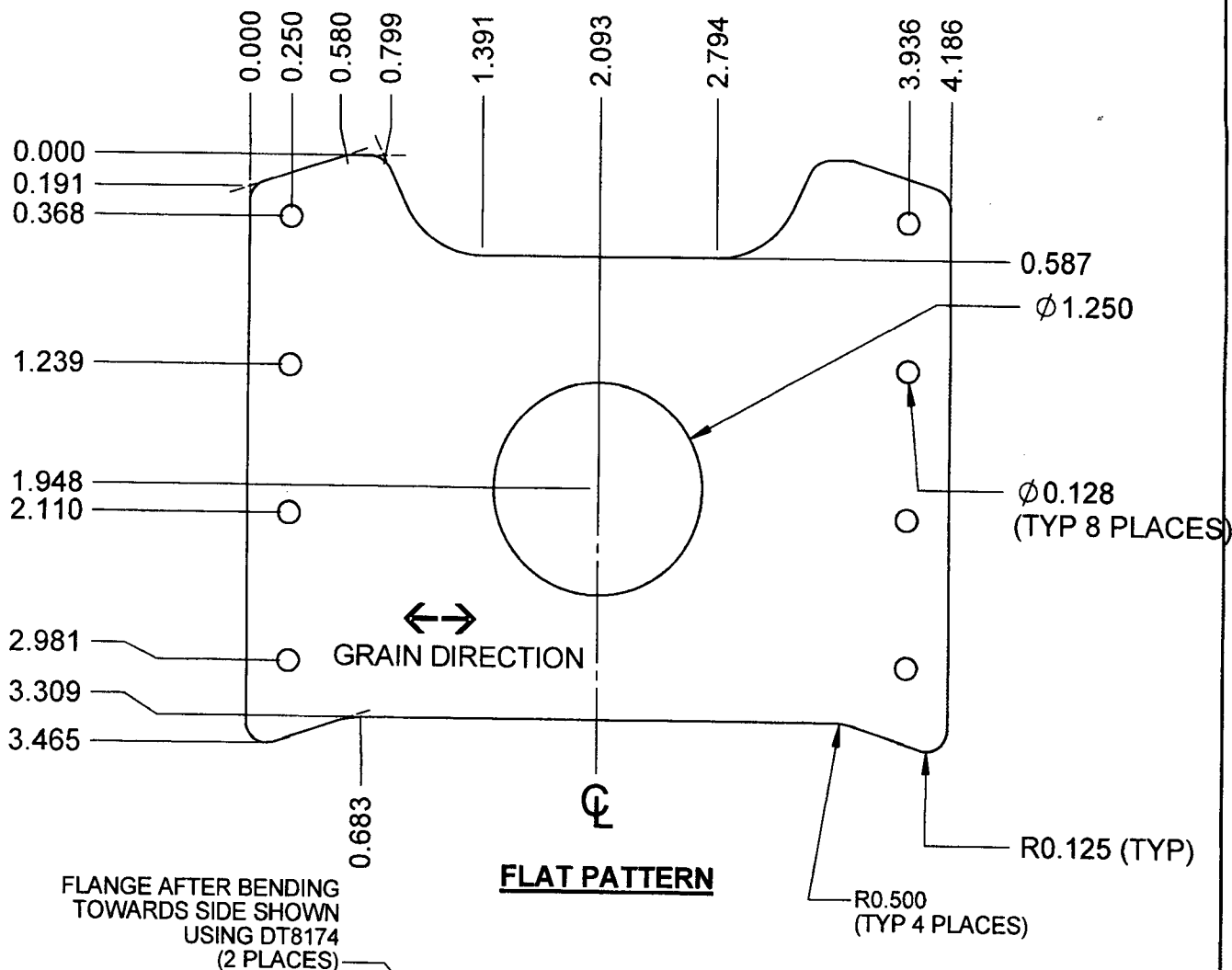
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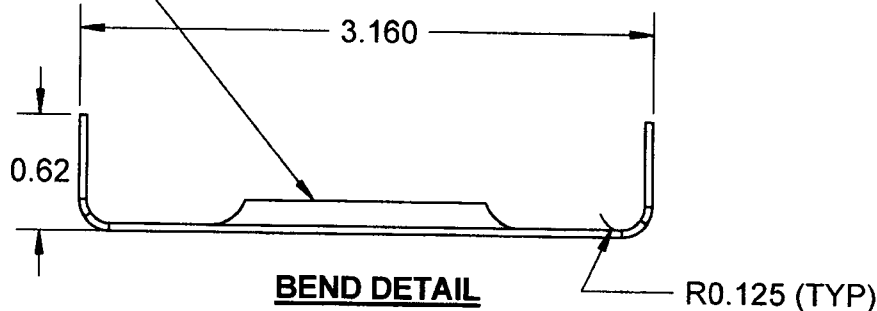
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)

RELEASED

de de re



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

83891

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

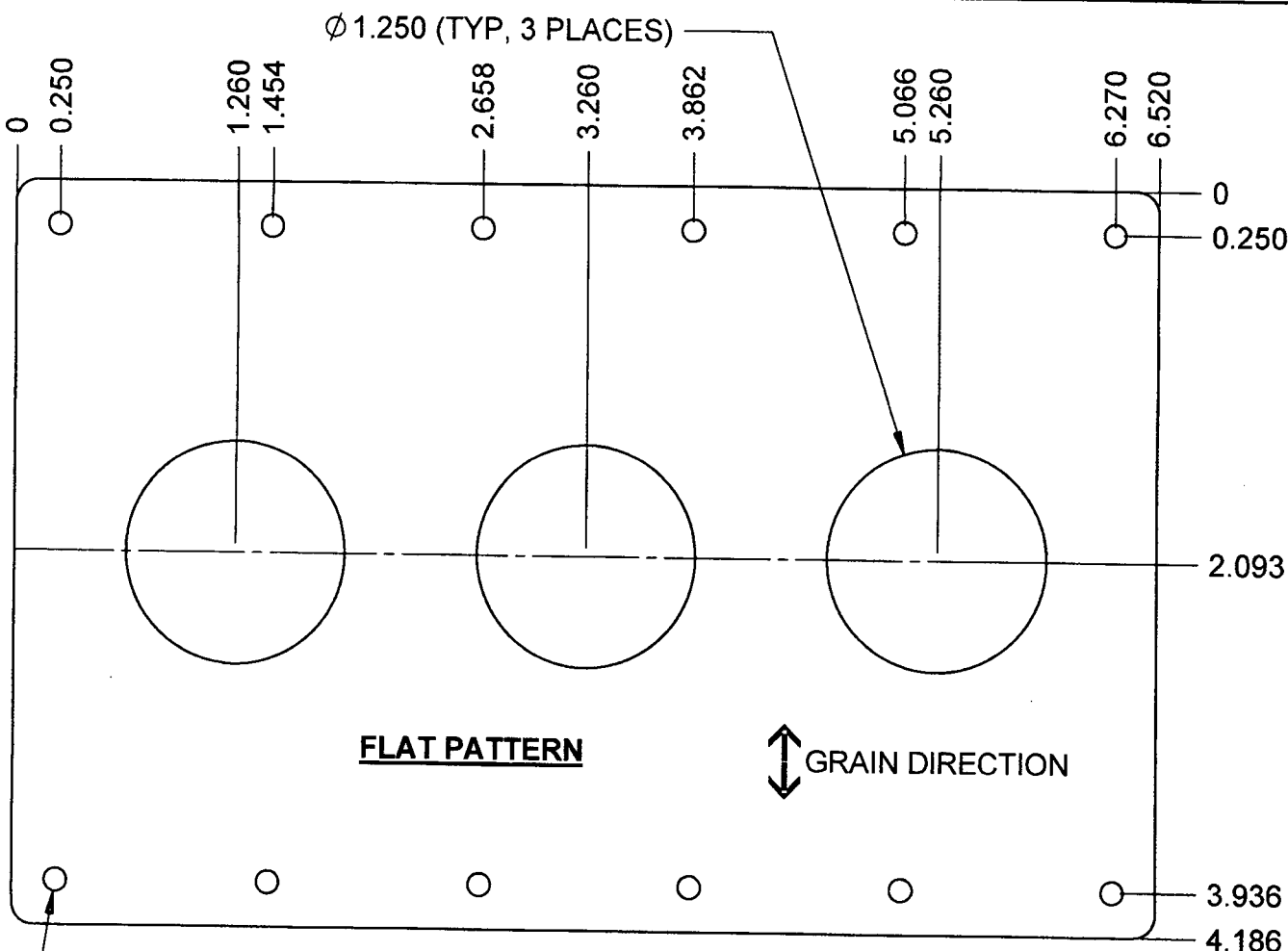
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

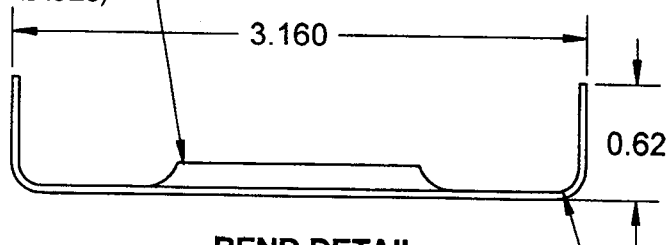


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

OK OK 20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

15871

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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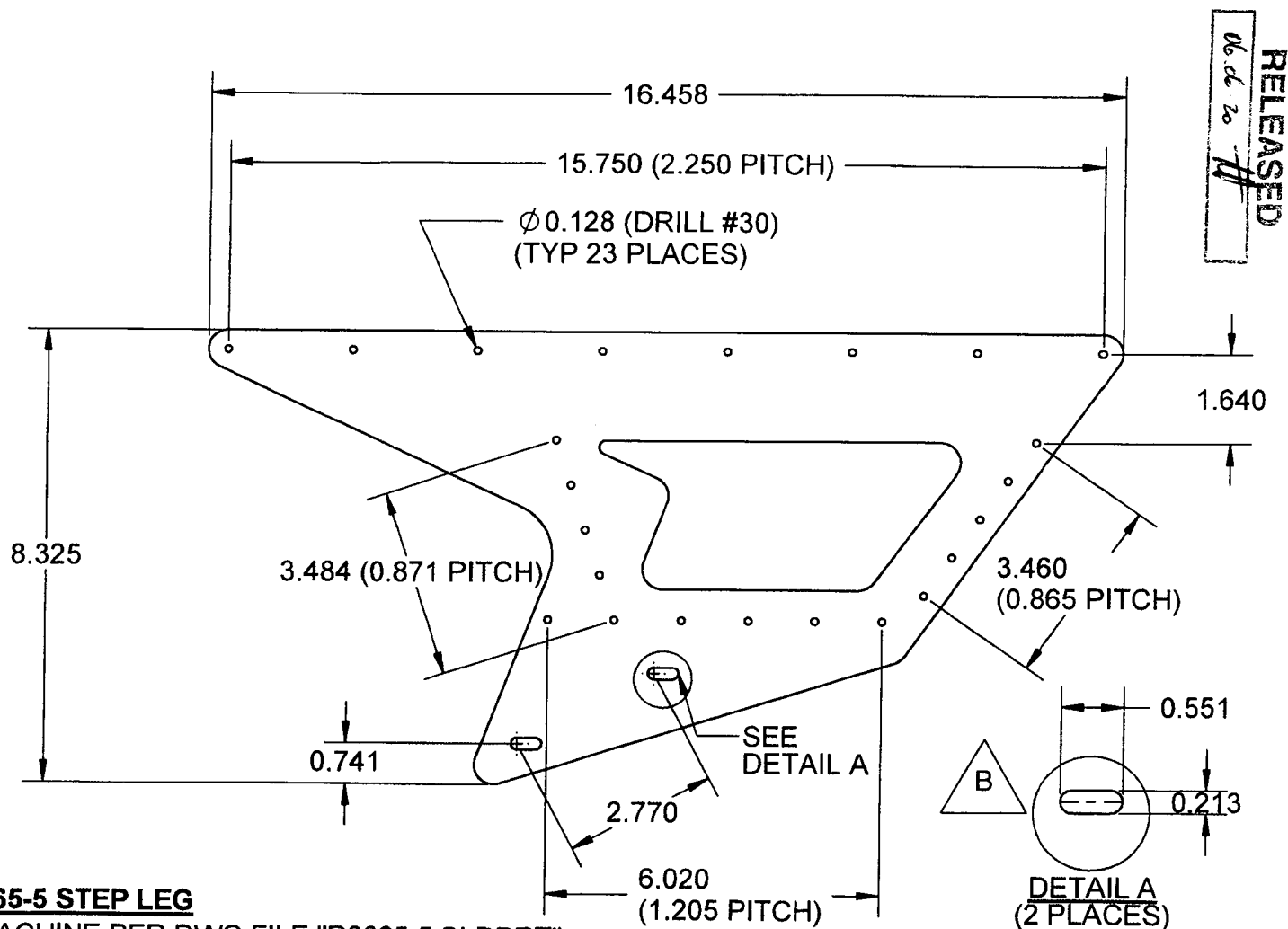
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN <i>CP</i>	DRAWN BY <i>CB</i>
CHECKED <i>BT</i>	APPROVED <i>[Signature]</i>
DATE 06.05.23	DRAWING NO. D3065 REV. B SHEET 4 OF 5
TITLE STEP LEG ASSEMBLY SCALE 1:3	



1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
 (REF DART SPEC M6061T6S.080)
 OR
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

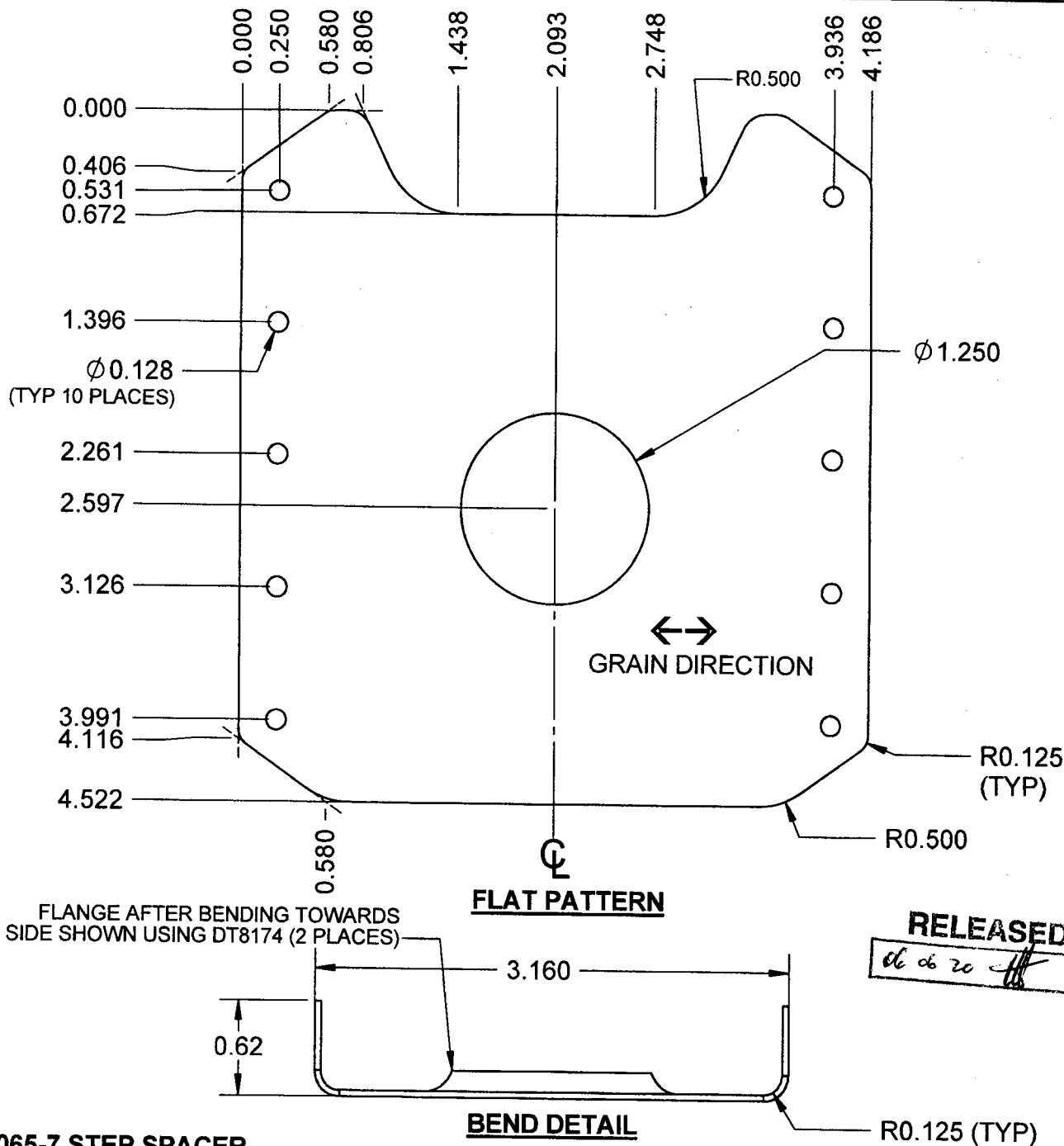
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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158841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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